

Work Order ID 55139

January 7, 2010 8:20:57 AM

9418 08/01 !



Page 1

Item ID: D3805-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, High Gear

Start Date: 1/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3805

Rev A

100

0.00



Large Fab

Memo

0.00

1- on D3806-7 , fill cut outs with hardcoat welding rod as per dwg D3805
2059 B Hardcoat Welding Rod
BATCH#: *m 113521*

2-weld D3806-7 to wearplate by positioning holes together as per dwg D3805
304 S.S. Welding Rod
BATCH #: *M 102421*

3-Transfer drill holes in bar

EL 10-1-8 (2)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.01.08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____




Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January 7, 2010 8:20:57 AM

Approvals: QC:	Process Plan:	Date:	Tooling:	Date:	Run Stop	 
	QC:	Date:	SPC (Y/N):	Date:		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00	⇒ Siobidos			②			
130 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo M112588 START 01:00 OVEN 300° FINISH 9:30	0.00	OK 10-01-8			②			
140 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00	JL 10-01-8			②	①		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55139

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Page 3

Item ID: D3805-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, High Gear

Start Date: 1/07/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Bond D3807-7 gasket to inner surface of wearplate using Scotch-grip adhesive.
A/R Scotch-grip batch: M113174

EP 10/01/08 (2)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8/06/08

(+2)

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

1b-1-0 (20) SL

Work Order ID 55139

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Page 4

Item ID: D3805-047

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly Aft, High Gear

Start Date: 1/07/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/01
MF 10-01-08

Picklist Print

January 7, 2010 8:20:56 AM

Page 1

Work Order ID: 55139

Parent Item: D3805-047

Parent Item Name: Wearplate Assembly Aft, High Gear



Start Date: 1/07/10

Required Date: 1/08/10

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 verified by:EC

Start Qty: 2.00

Required Qty: 2.00



Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3805-7  Plate		Manufactured	No			100	Each	6.0000	2.0000 	<u>EL</u>	10-1-8	

Warehouse Loc Qty Loc Code
Location

Main Warehouse
WA
52839

6
6

2



D3806-7  Bar		Manufactured	No			100	Each	12.0000	2.0000 	<u>EL</u>	10-1-8	
--	--	--------------	----	--	--	-----	------	---------	---	-----------	--------	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
46787
52854

12
4
8

2

D3807-7  Gasket		Manufactured	No			150	Each	10.0000	2.0000 	<u>EP 10/01/08</u>		
---	--	--------------	----	--	--	-----	------	---------	---	--------------------	--	--

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
52838

10
10

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

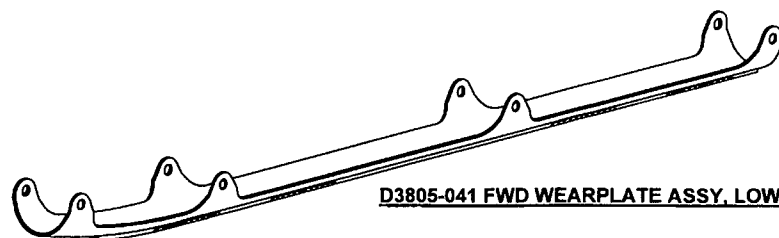
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4

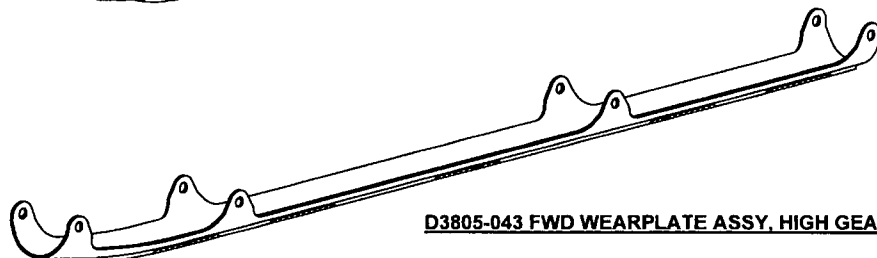
3 2 1

D



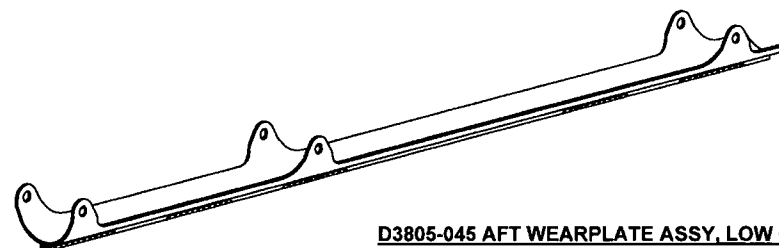
D3805-041 FWD WEARPLATE ASSY, LOW GEAR

C



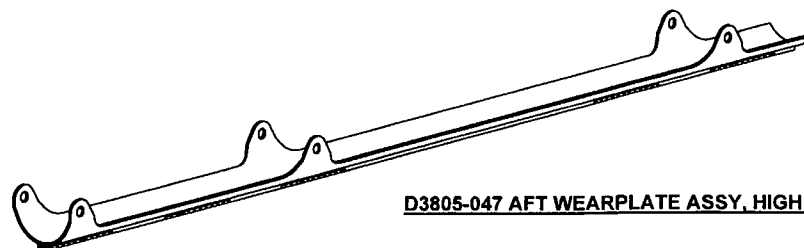
D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

B



D3805-045 AFT WEARPLATE ASSY, LOW GEAR

A



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

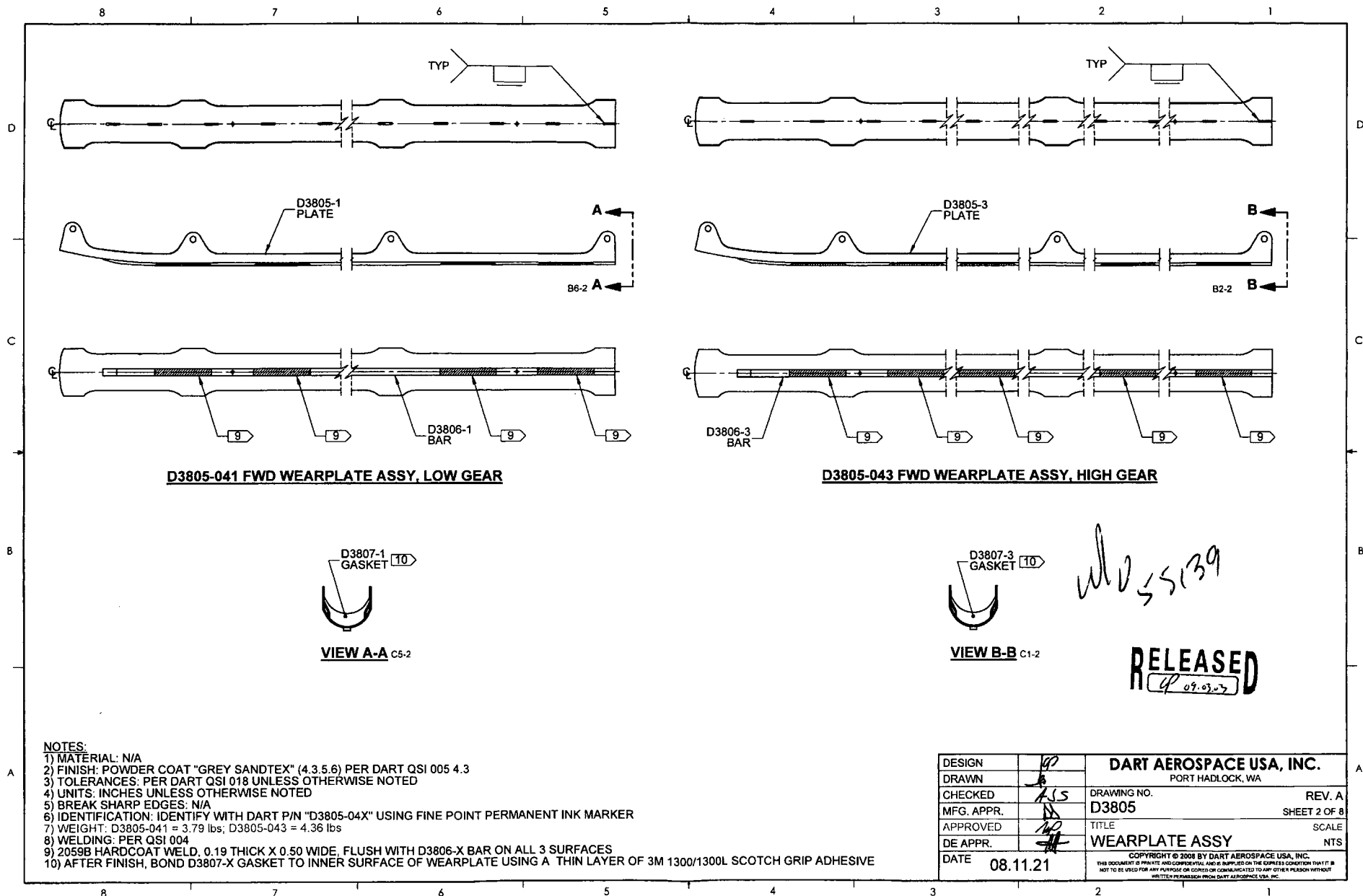
3 2 1

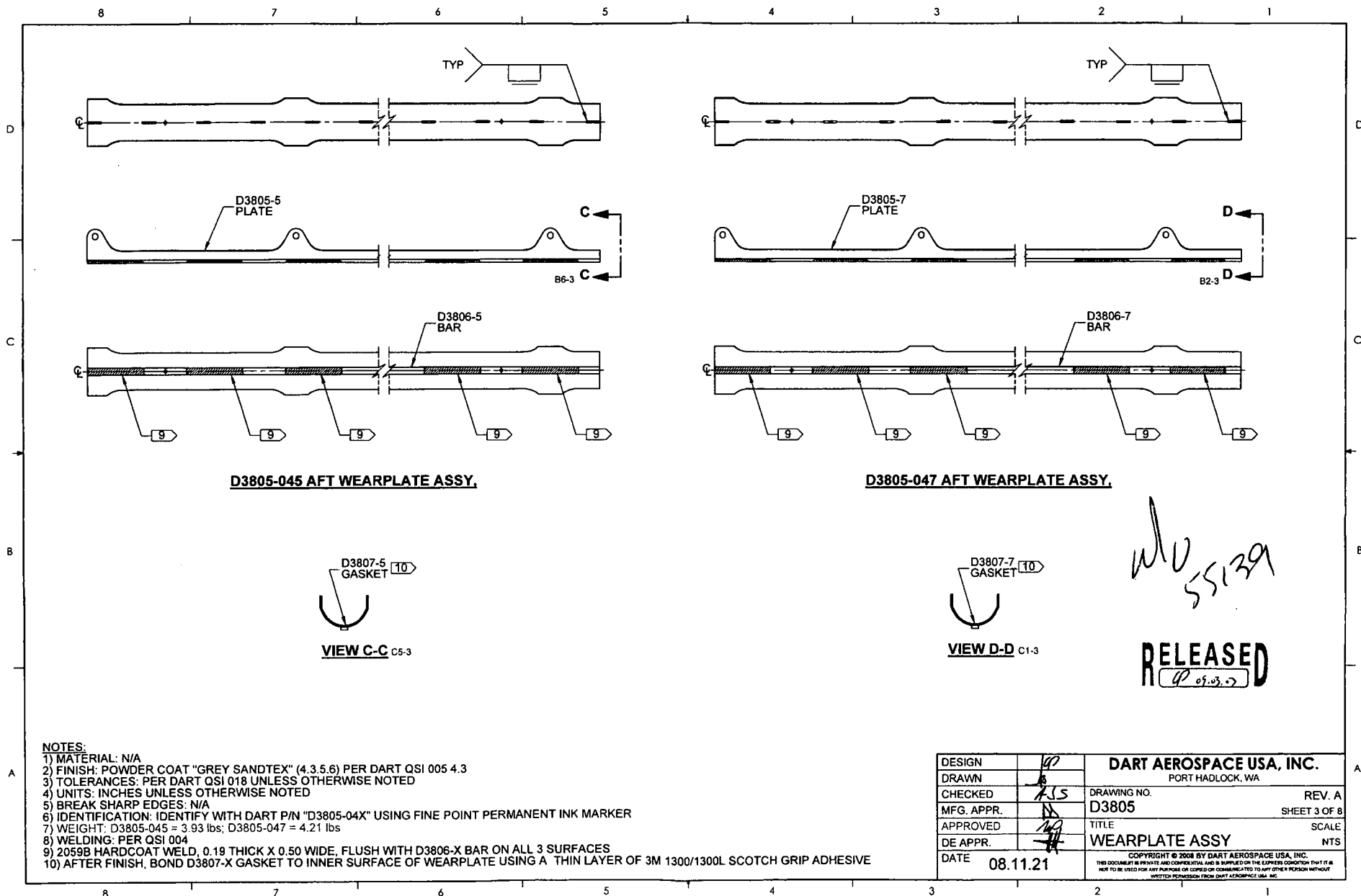
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1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

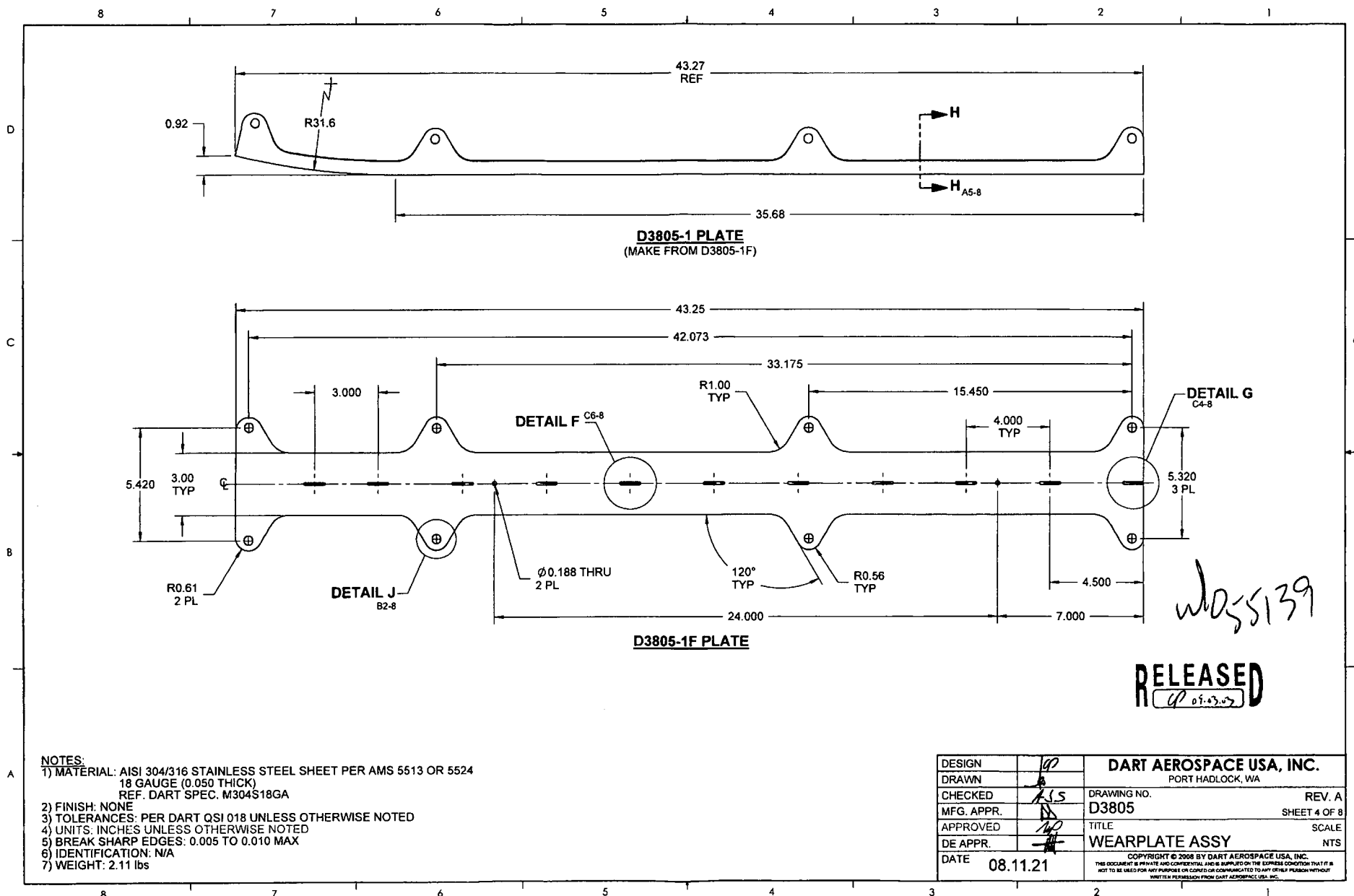
WLO
55139

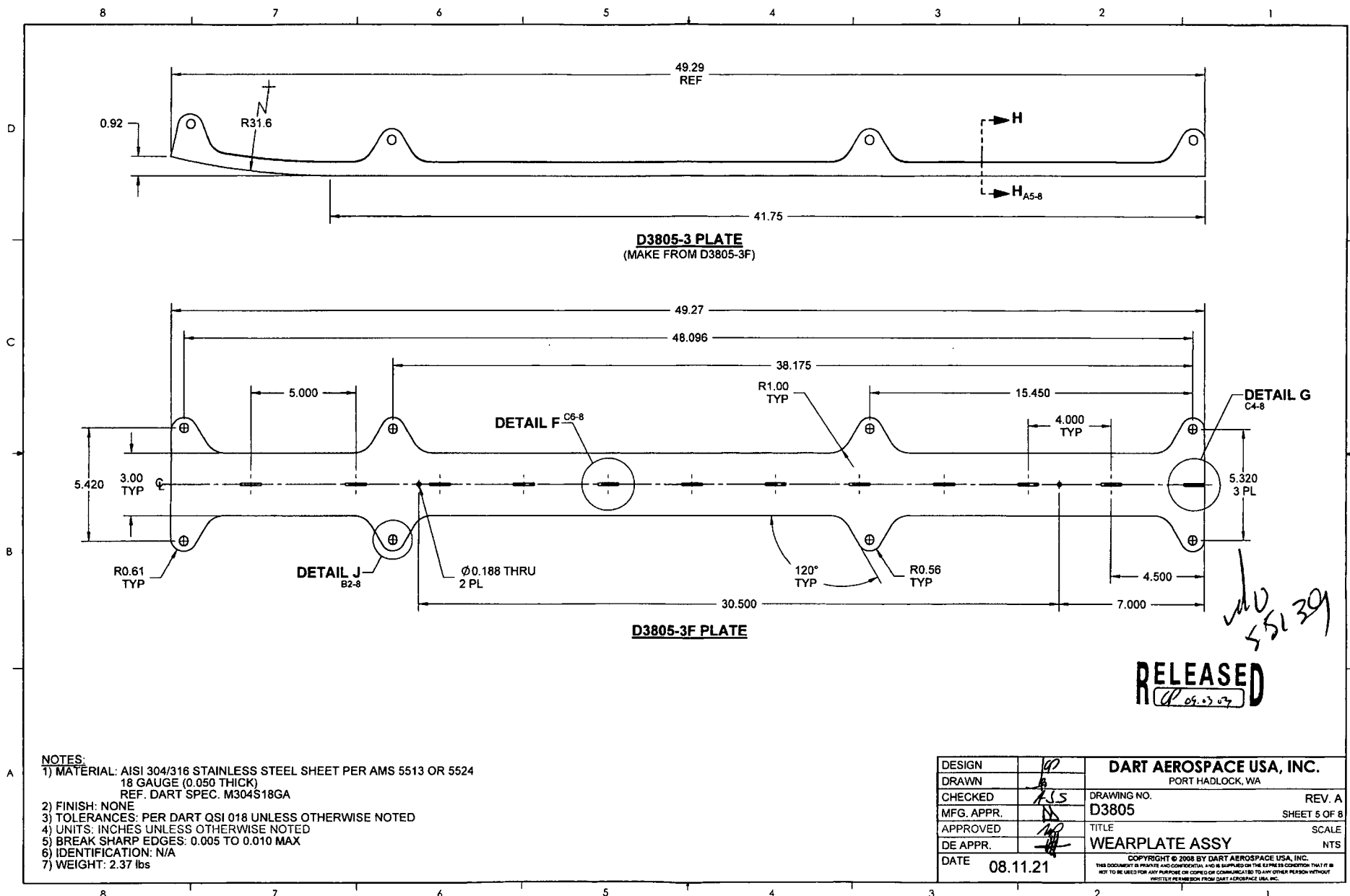
RELEASED
09.09.03
Pw ECN 09-538

A	NEW ISSUE	MB	08.11.21
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DRAWN	15	PORT HADLOCK, WA	
CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3805	SHEET 1 OF 8
APPROVED	42	TITLE	SCALE
DE APPR.	42	WEARPLATE ASSY	NTS
DATE	08.11.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE, OR TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

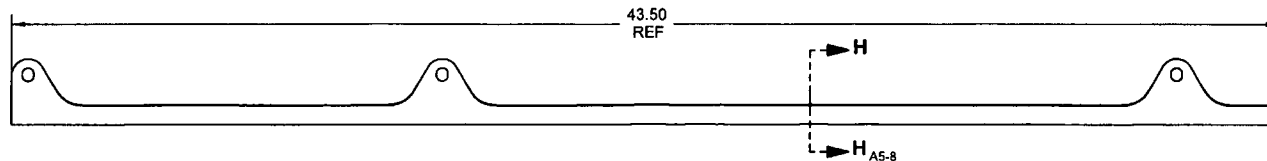




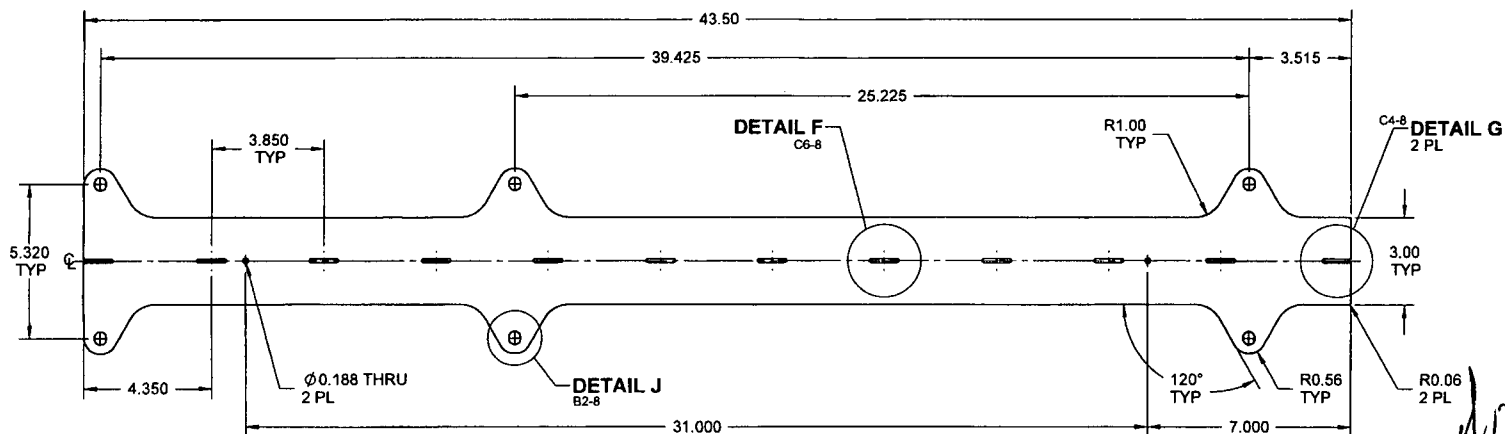




8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

Handwritten: 55139

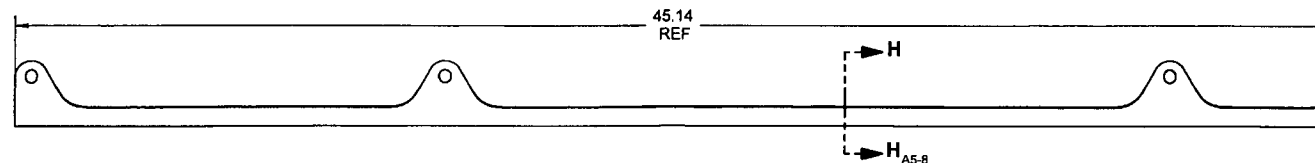
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Handwritten: 09-03-03

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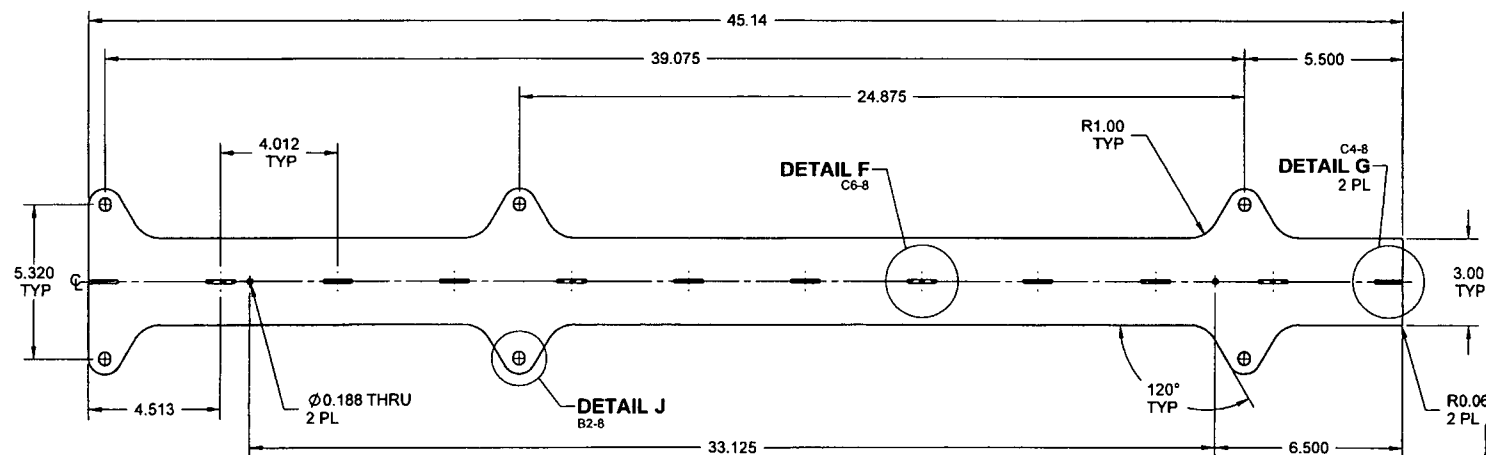
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	<i>Handwritten:</i> 100	DART AEROSPACE USA, INC.	
DRAWN	<i>Handwritten:</i> 115	PORT HADLOCK, WA	
CHECKED	<i>Handwritten:</i> 115	DRAWING NO.	REV. A
MFG. APPR.	<i>Handwritten:</i> 115	D3805	SHEET 6 OF 8
APPROVED	<i>Handwritten:</i> 115	TITLE	SCALE
DE APPR.	<i>Handwritten:</i> 115	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3805-7 PLATE
(MAKE FROM D3805-7F)



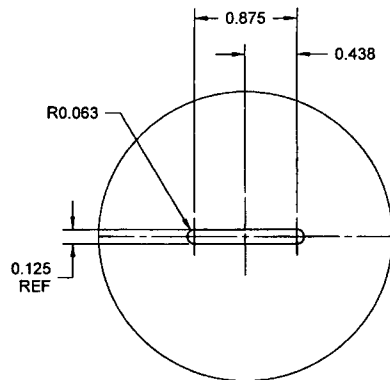
D3805-7F PLATE

RELEASED
49 09.03.07

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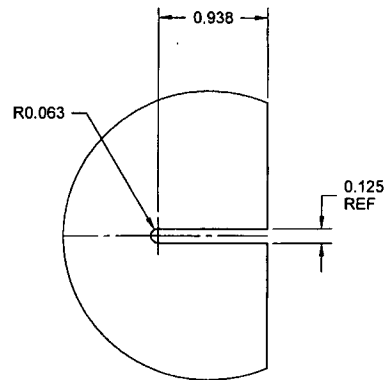
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	49	DART AEROSPACE USA, INC.	
DRAWN	49	PORT HADLOCK, WA	
CHECKED	ALS	DRAWING NO.	REV. A
MFG. APPR.	49	D3805	SHEET 7 OF 8
APPROVED	49	TITLE	SCALE
DE APPR.	49	WEARPLATE ASSY	NTS
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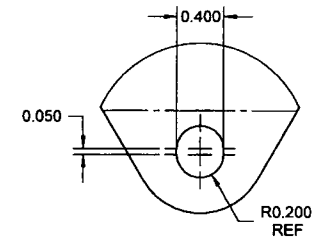
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SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



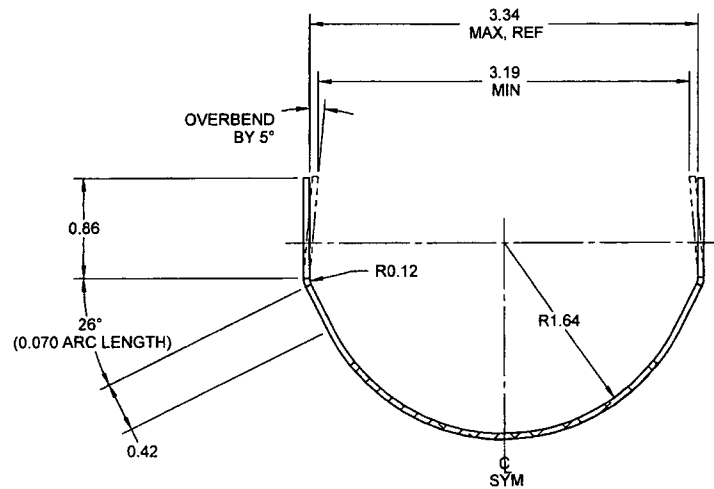
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C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

WLO
SS139
RELEASED
07.09.03

DESIGN	190	DART AEROSPACE USA, INC.	
DRAWN	190	PORT HADLOCK, WA	
CHECKED	190	DRAWING NO.	REV. A
MFG. APPR.	190	D3805	SHEET 8 OF 8
APPROVED	190	TITLE	SCALE
DE APPR.	190	WEARPLATE ASSY	NTS
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